

91396

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N900040100

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

Start Date: 10/10/2012 **Start Qty:** 40.00

40

Customer:

Required Date: 10/22/2012 **Req'd Qty:** 40.00

12.10.08

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

Work Order ID 91396

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Tuesday, October 09, 2012 10:14:34 AM

Item ID: D3278-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Support
Start Date: 10/10/2012 Start Qty: 40.00 *40* Cust Item ID:
Required Date: 10/22/2012 Req'd Qty: 40.00 *40* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00	D.A	12/10/12		40	0		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				40	NA	12/10/15	
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11-20 OVEN TEMPERATURE:								
	FINISH TIME: 11-50								

M122878

3200F

11-50

40x ✓ 12/10/15

Work Order ID 91396

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Tuesday, October 09, 2012 10:14:34 AM

Item ID: D3278-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 10/10/2012 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 10/22/2012 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: SGA	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

ML5 12-10-16

Picklist Print

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Work Order ID: 91396

Parent Item: D3278-1

Parent Item Name: Support

Start Date: 10/10/2012

Required Date: 10/22/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.000 6061-T6 Bar 1.00 x 2.00		Purchased	No			100	f	20.9480	0.2337	9.84			

Location

Loc Qty

Loc Code

MAT

10.158

112567

0

121660

10.158

MAT004

10.79

122081

10.79

122321

RT 12-10-10

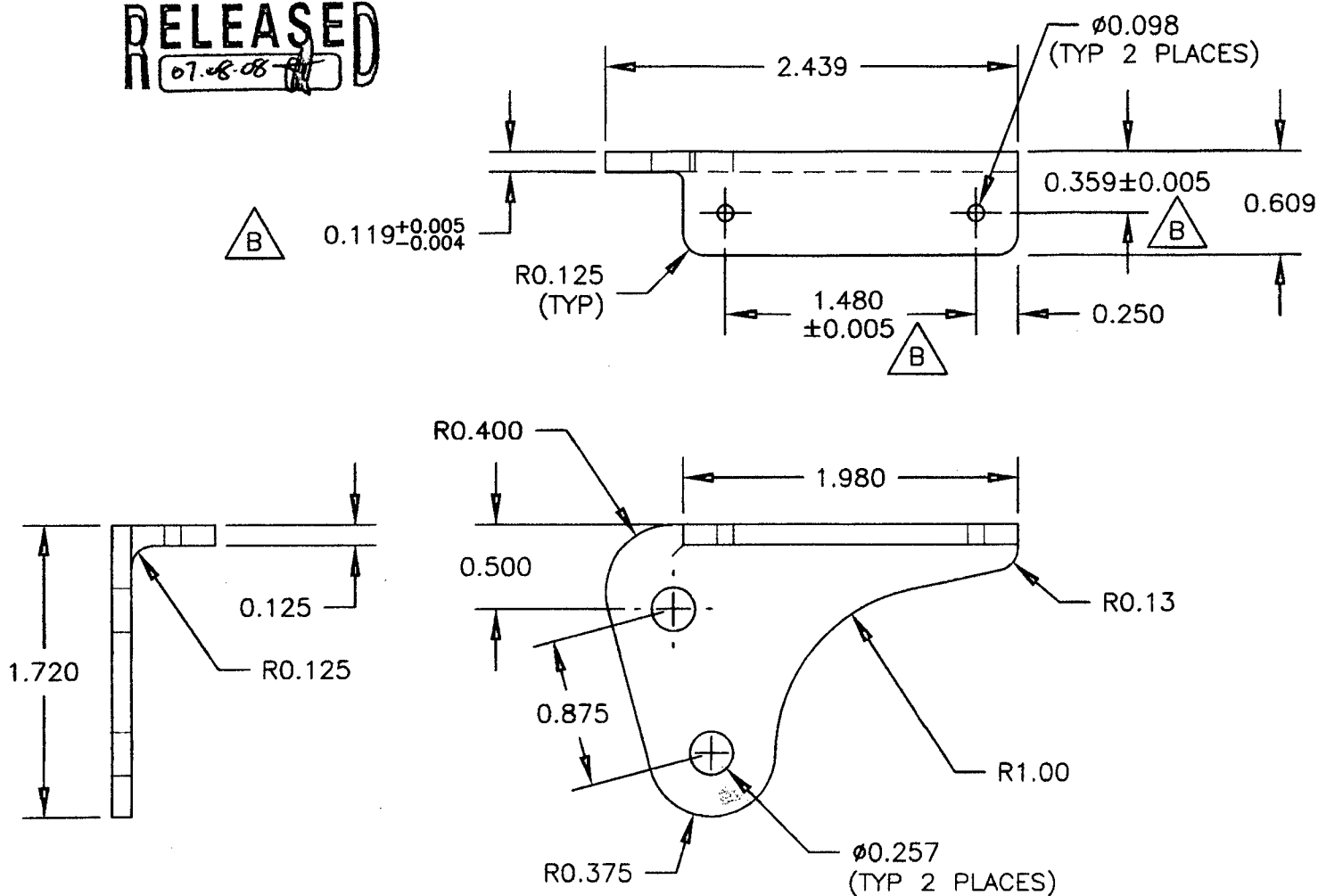
49.84

0.218



DESIGN <i>qp</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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
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DART AEROSPACE LTD		Work Order: 91396
Description: Support		Part Number: D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	/			
0.359	+/-0.005	.361	/			
0.609	+/-0.010	.615	/			
0.250	+/-0.010	.246	/			
1.480	+/-0.005	1.480	/			
R0.125	+/-0.010	.125	/			
0.119	+0.005/-0.004	.120	/			
2.439	+/-0.010	2.442	/			
1.980	+/-0.010	1.980	/			
R0.13	+/-0.030	.13	/			
Ø0.257	+0.005/-0.000	.258	/			
R0.375	+/-0.010	.375	/			
0.875	+/-0.010	.875	/			
0.500	+/-0.010	.498	/			
R0.400	+/-0.010	.400	/			
R1.00	+/-0.030	1.00	/			
1.720	+/-0.010	1.720	/			
R0.125	+/-0.010	.125	/			
0.125	+/-0.010	.125	/			

Measured by: 	Audited by: D.A.	Prototype Approval:	N/A
Date: 2.10.11	Date: 12/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC 